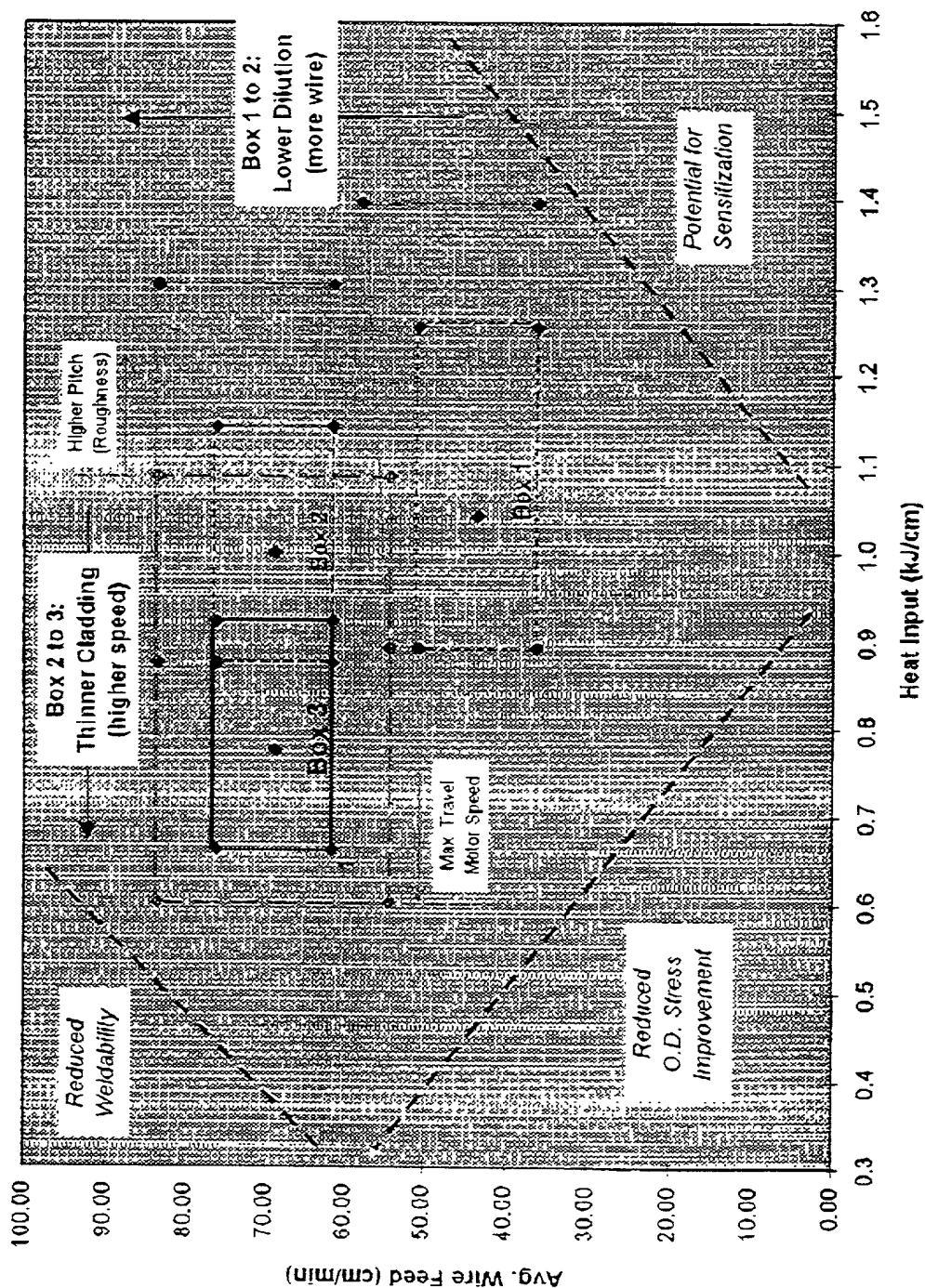


FIG. 1

Heat Boxes 1, 2, 3 (with Reference Points)



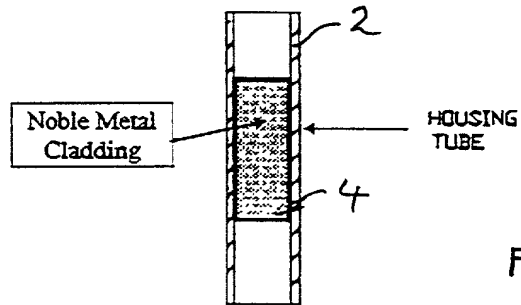
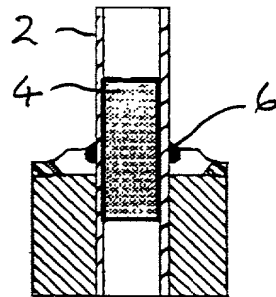
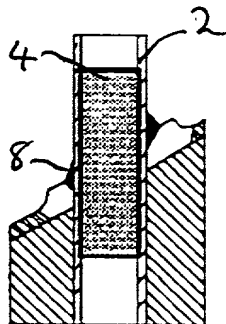


FIG. 2A



HORIZONTAL
J-WELD

FIG 2B



ANGLED
J-WELD

FIG 2C

406406 0400

40064037 032003
202210 604500

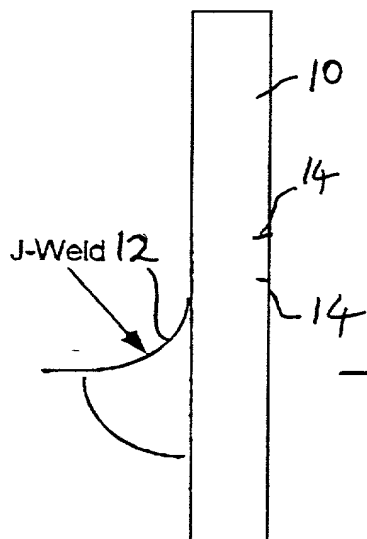


FIG. 3A
Shallow
Cracks

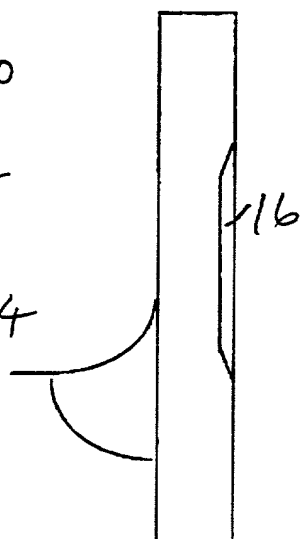


FIG. 3B
Cracks
Removed

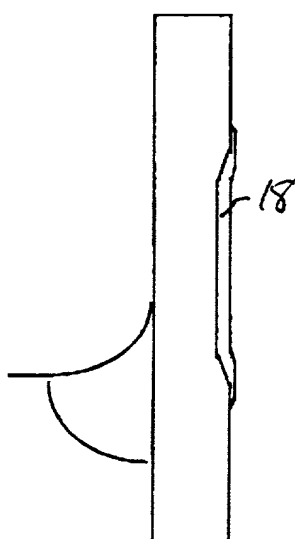


FIG. 3C
Counterbore
NM Cladded

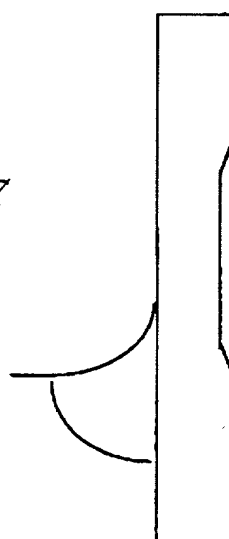
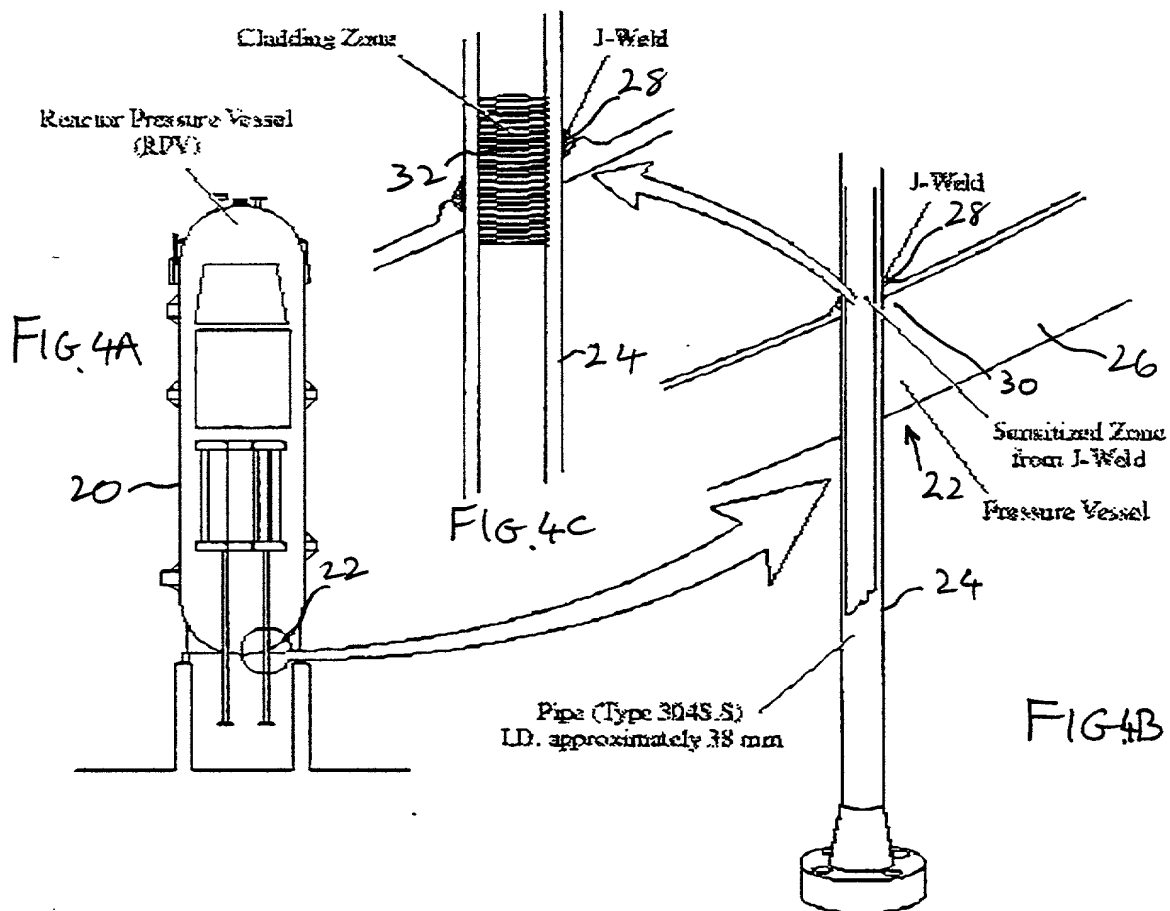


FIG. 3D
ID Surface
Finished

202503 1005463 043203



ICMH Mitigation

FIG. 4

202210165001

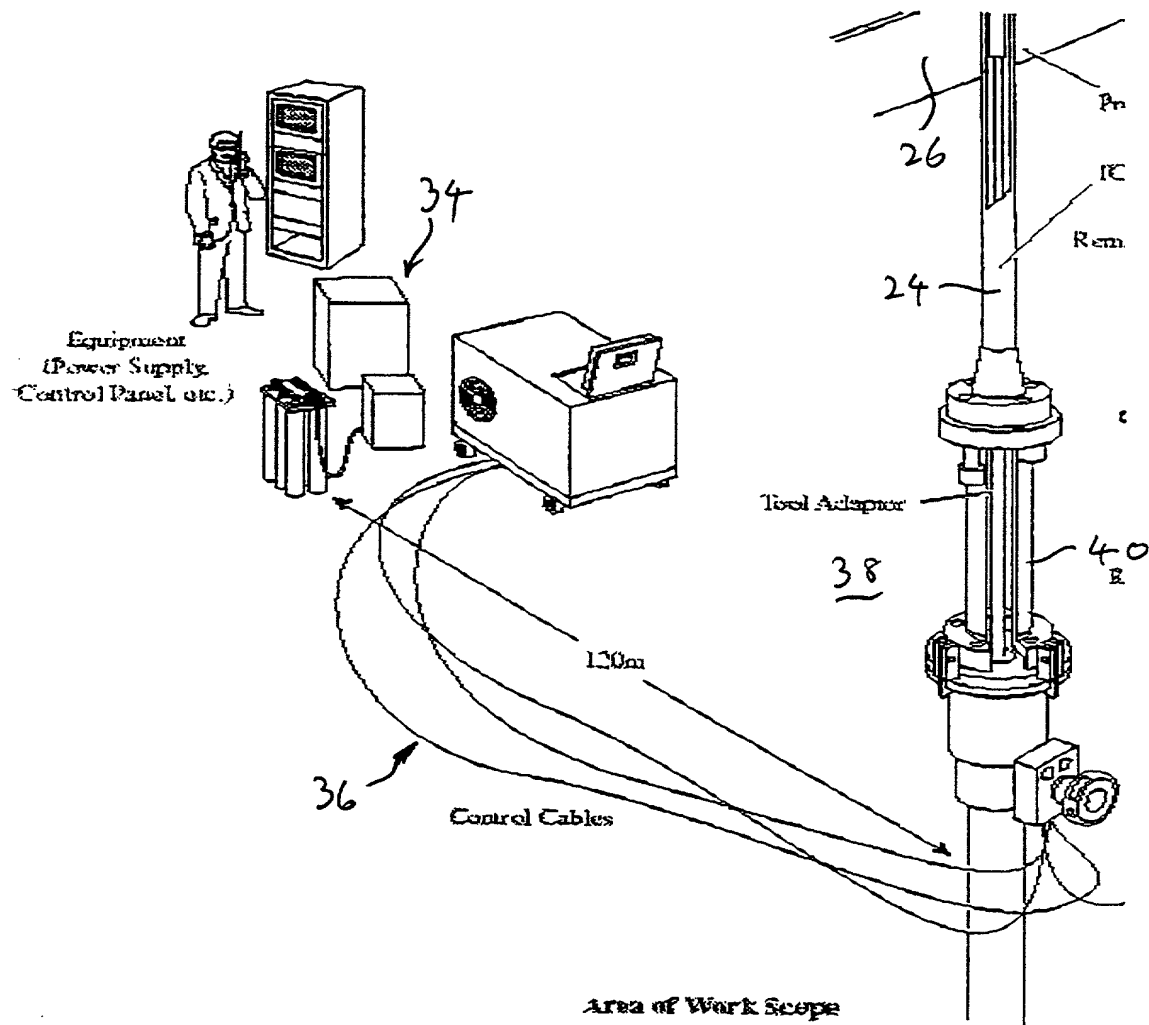


FIG. 5

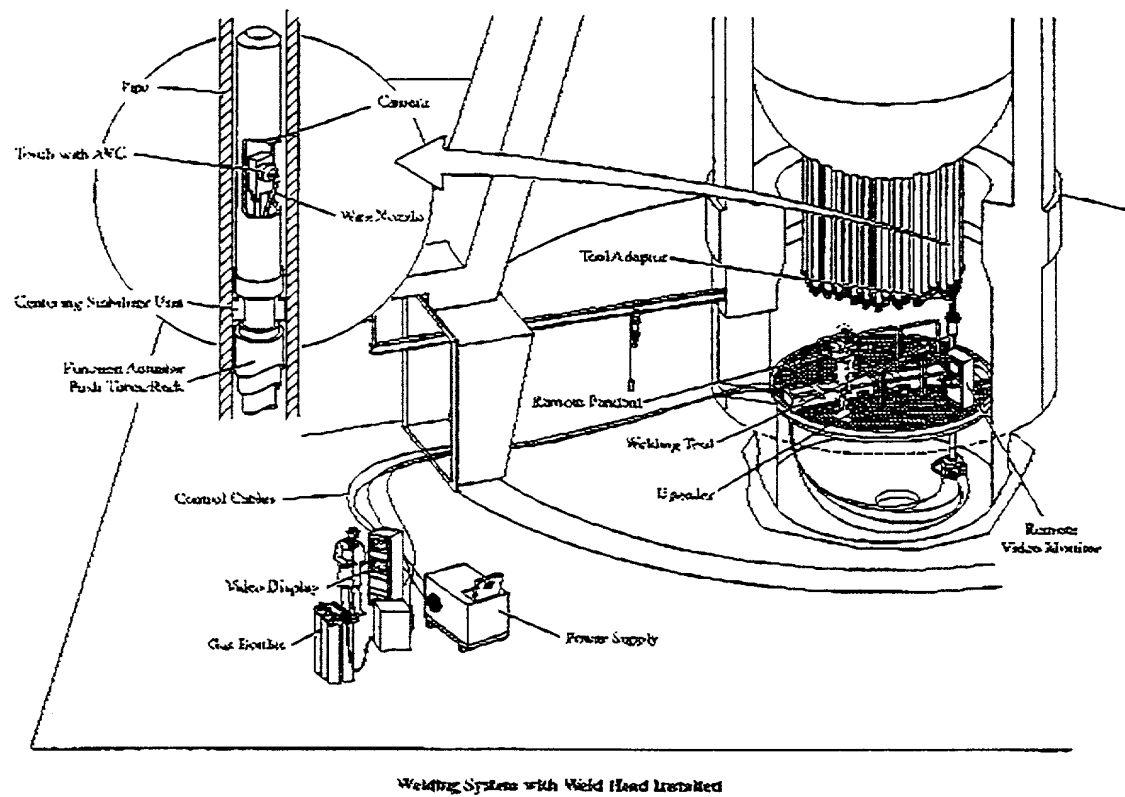


FIG. 6

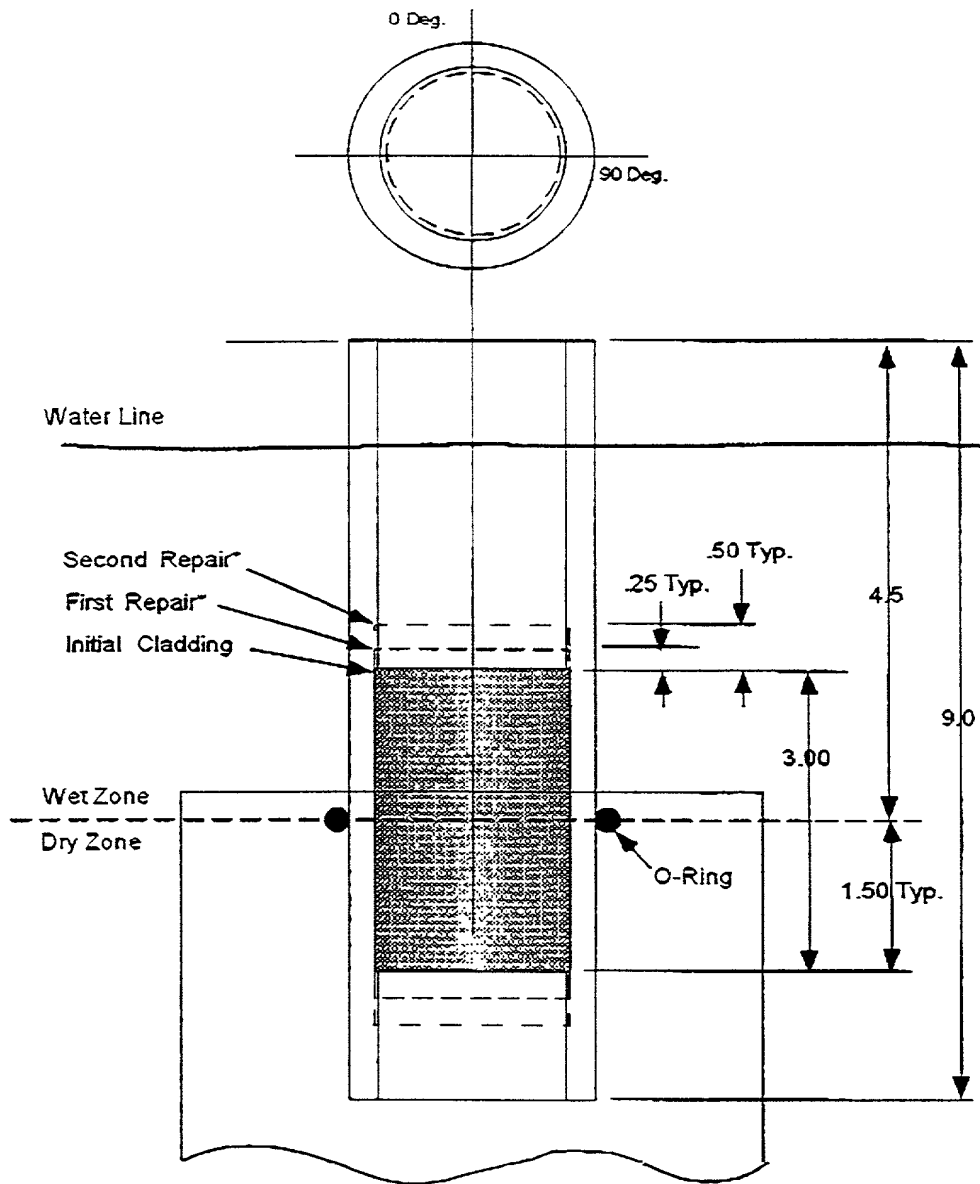
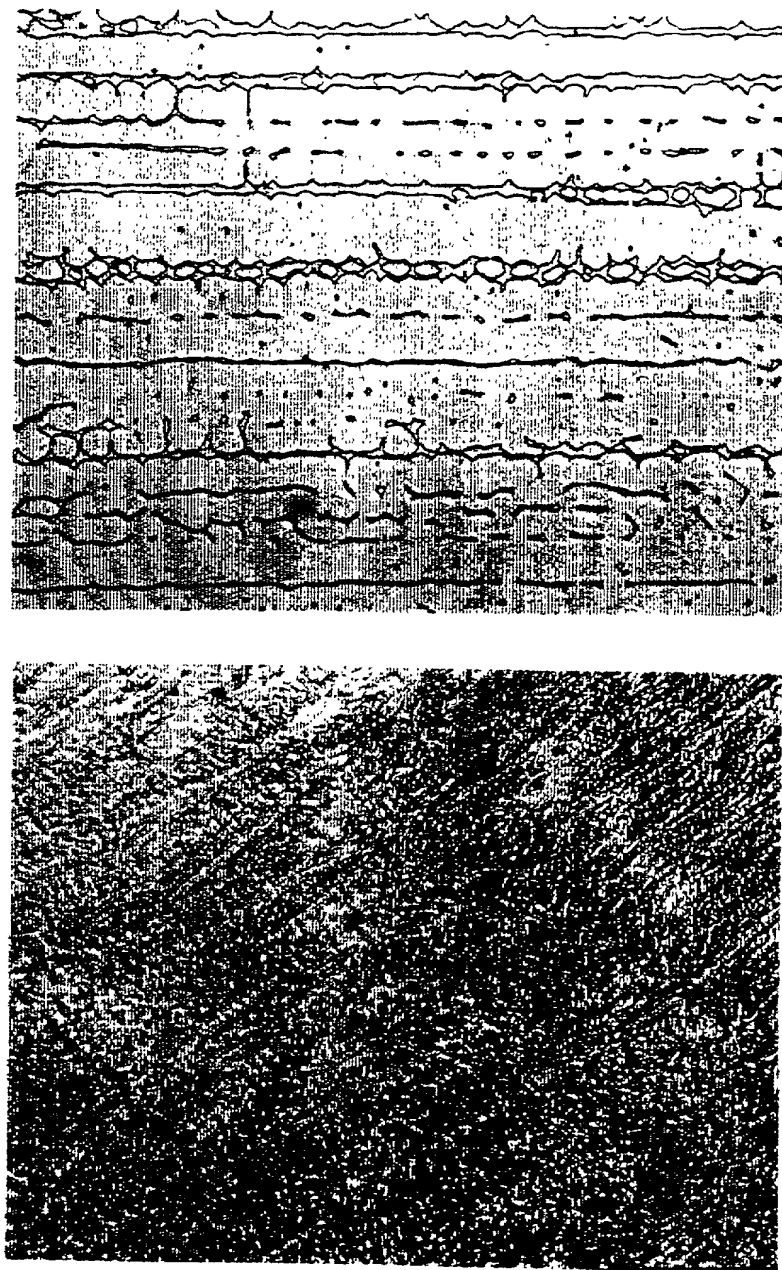


FIG. 7

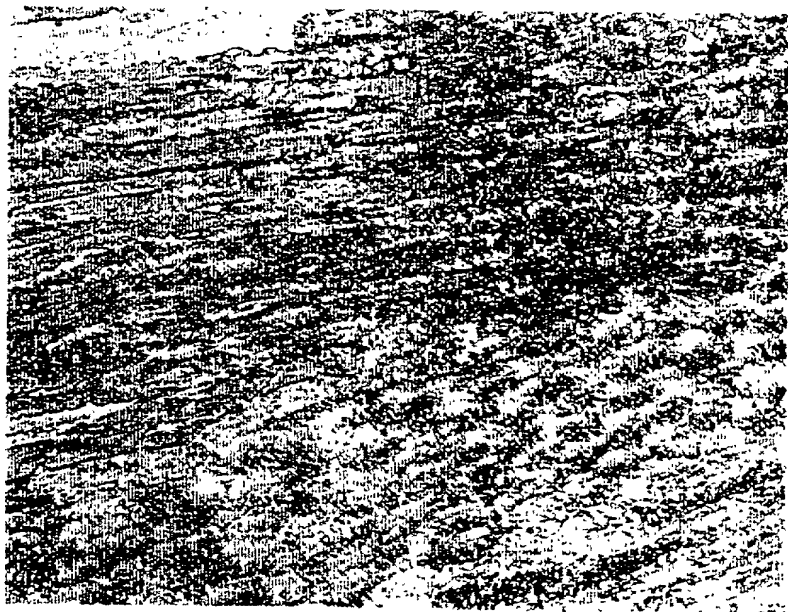


(A)

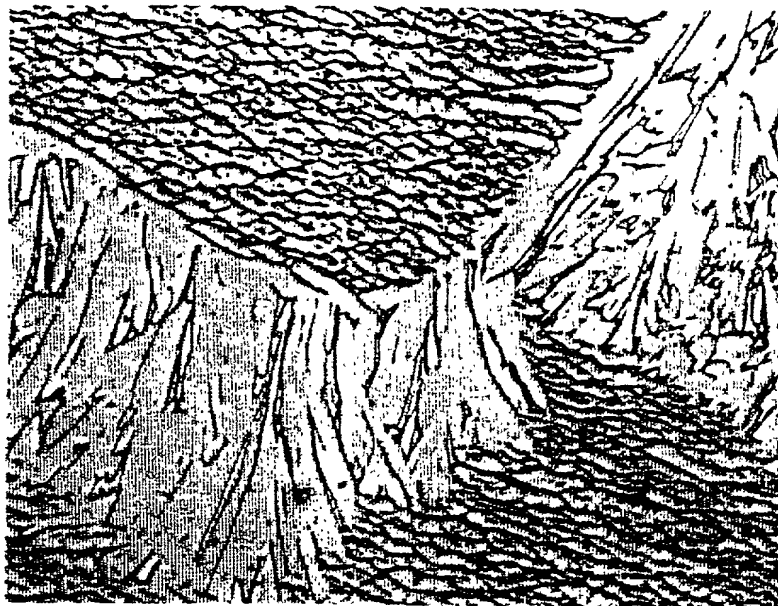
(B)

Micrographs Comparing Ferrite Size and Distribution for NM Cladding with Type 316L + 1Pd Filler, 800 X Magnification. (A) Mechanized ICMH Cladding, (B) Manual Cladding

FIG. 8



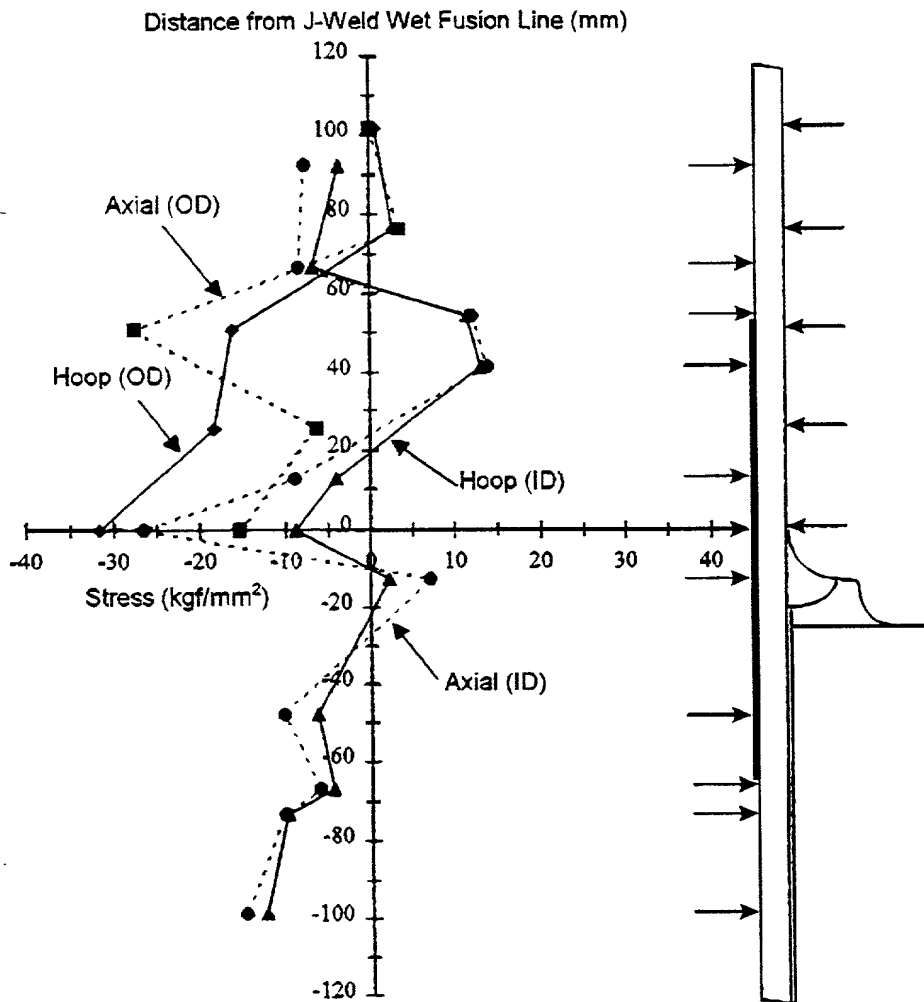
(A)



(B)

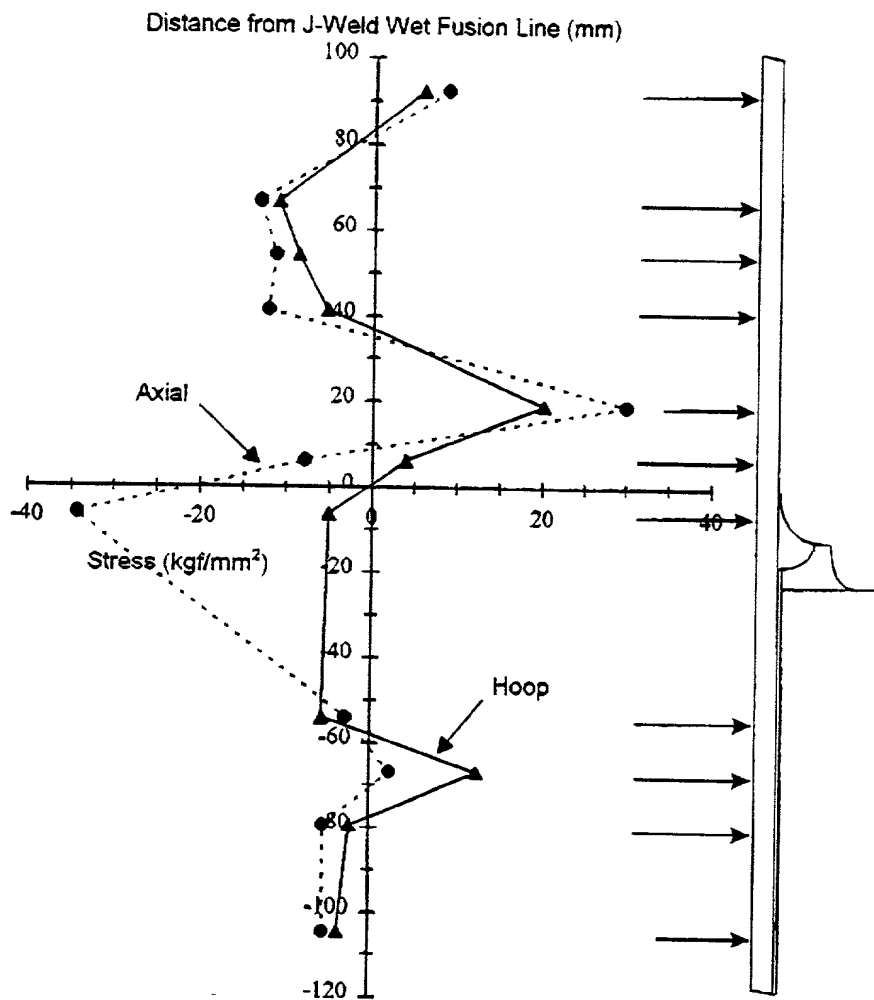
Micrographs Comparing Ferrite Size and Distribution for NM Cladding with Type 308L +1Pt Filler, 800 X Magnification. (A) Mechanized ICMH Cladding, (B) Manual Cladding

Fig. 9



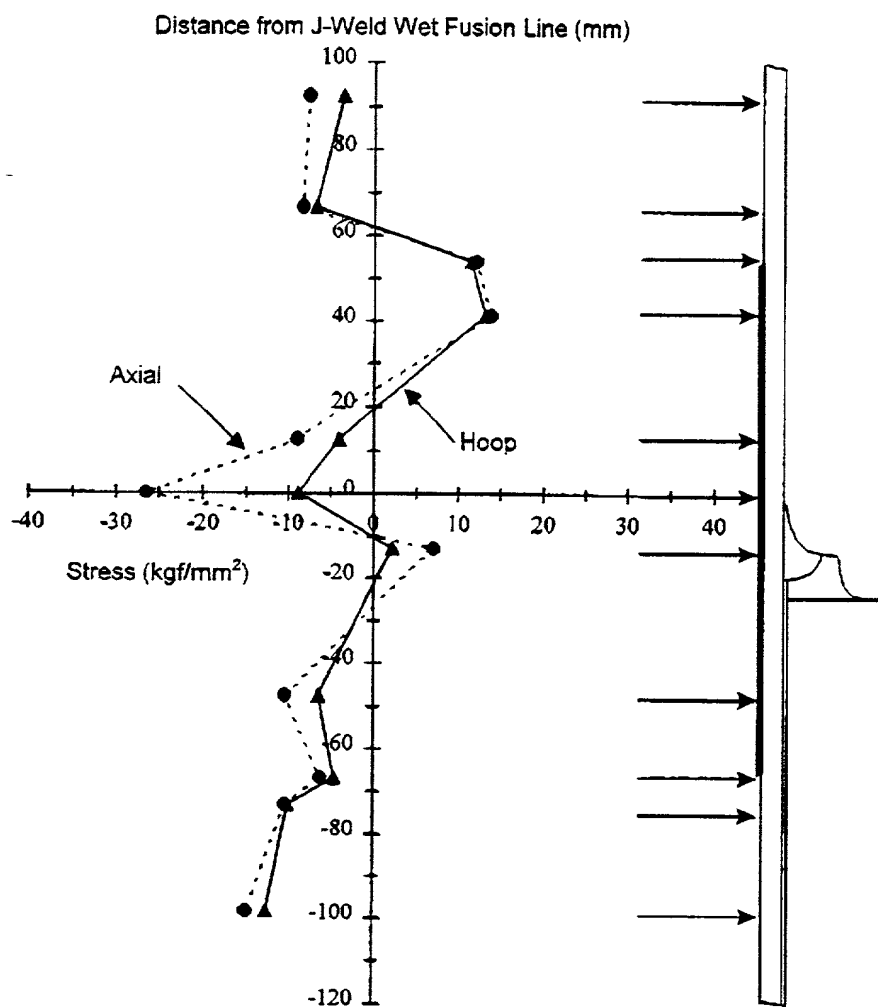
ID/OD Residual Stress (Clad)

FIG. 10A



ID Residual Stress (no clad)

FIG. 10 B



ID Residual Stress (clad)

FIG. 10C